

5059278



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 175569



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/6/18

Job Tracking No:

Due Date: 4/27/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/26/18	0.00	0.00	Start Up Large Fab-4		SA 2018-04-09
110	Large Fab	1 pcs		4/26/18	0.00	0.99	Large Fab 2		SA 2018-04-09
120	QC	1 pcs		4/26/18	0.00	0.00	QC9		GA
130	QC	1 pcs		4/26/18	0.00	0.00	QC5		GA
140	HandFinish	1 pcs		4/26/18	0.00	0.18	HandFinish1		GA
150	QC	1 pcs		4/26/18	0.00	0.00	QC7-2		SA 18-4-9
180	Large Fab	1 pcs		4/26/18	0.00	0.99	Large Fab,2		SA 18-04-09
190	QC	1 pcs		4/26/18	0.00	0.00	QC10		
200	QC	1 pcs		4/26/18	0.00	0.00	QC5		
210	HandFinish	1 pcs		4/26/18	0.00	0.18	HandFinish1		SA 18-04-09
220	Powdercoat	1 pcs		4/26/18	0.00	0.29	Powdercoat1		BR 18-4-10
230	HandFinish	1 pcs		4/27/18	0.00	0.18	HandFinish3		UDAS 18-4-10
240	QC	1 pcs		4/27/18	0.00	0.00	QC3		33
250	Packaging	1 pcs		4/27/18	0.00	0.00	Packaging1-3		DAS-03
260	QC	1 pcs		4/27/18	0.00	0.00	QC4		58
265	DC	1 pcs		4/27/18	0.00	0.00	DC		9-89 DAS
270	Packaging	1 pcs		4/27/18	0.00	0.00	Packaging3-1		58 APR 1
280	QC21-FG	1 Ea		4/27/18	0.00	0.00	QC21		21 APR 17 2018 9-89

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 9:55 OVEN TEMPERATURE: 820 FINISH TIME: 10:05

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	5047606 → 2x
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	5050520 → 2x
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	5059101
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	5054130
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab	5051986
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab	5041171 → 16x
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	5017689
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	5045860
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	5041116
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	5057382
D2618	Bushing	2 Ea (2 ea)	250-Packaging	5013411
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging	50419850
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	5057382
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	5059873
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	5038764
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	5045701
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	5041167
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	5015269
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	5045845
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	5055056
DSI 9410-011	Amends Installation Of D350-591-311/-312 Steps	1 Ea (1 ea)	270-Packaging	5059545

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	79	0
	D3219-1	2	93	0
	D3272-1	1	10	0
180-Large Fab	D3065-041	1	7	0
	D3066-1	2	64	0
	MS20600-AD4W4	16	1,507	0
250-Packaging	AN3-35A	2	238	0
	AN4-13A	8	900	0
	AN5-36A	2	208	0
	D2230-3	4	154	0
	D2618	2	402	0
	D2856-400-720	2	146	0
	D3235-1	2	232	0
	D3278-041	1	10	0
	MS21042L3	2	2,563	0
	MS21042L4	8	3,873	0
	MS21042L5	2	1,052	0
	NAS1149D0363J	4	2,883	0
	NAS1149D0463J	16	5,730	0
	NAS1149D0563J	4	1,794	0
	DSI 9410-011	1	2	0

Part Specifications

Specifications could not be found.

Plex 4/6/18 12:57 PM Dart.Gagnon.Michelle



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Container No: S059278



Part: D350-591-311

Job No: 175569

Serial No/Batch: S059278

Revision:

Inspector:

Date: 04/09/18



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002524	S061144	AN3-35A	Bolt	S017089	ST348	2
002524	S061143	AN4-13A	Bolt	S045860	ST344	8
002524	S061142	AN5-36A	Bolt	S041116	ST336	2
002524	S061130	D2230-3	Mounting Lug	s051382	ST521	4
002524	S061141	D2618	Bushing	S043411	ST008	2
002524	S061133	D2856-400-720	Abrasion Strip 4" X 7.20"	s046950	ST418	2
002524	S061128	D3235-1	Mounting Lug	s051314	ST522	2
002524	S061134	D3278-041	Support Assembly	s059873	ST522	1
002524	S061125	DSI 9410-011	Amends Installation Of D350-591-311/-312 Steps	S059545	FG123	1
002524	S061140	MS21042L3	Nut	S038764	ST303	2
002524	S061139	MS21042L4	Nut	S045901	ST303	8
002524	S061138	MS21042L5	Nut	S041167	ST303	2
002524	S061137	NAS1149D0363J	Washer	S015269	ST263	4
002524	S061136	NAS1149D0463J	Washer	S045845	ST263	16
002524	S061135	NAS1149D0563J	Washer	S039036	ST263	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/16/18 7:43 AM dart.quirion.sonia

Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.